

Work Order ID 59979

Tuesday, June 22, 2010 10:16:04 AM



Page 1

Item ID:	D3929-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Gusset Assembly					
Start Date:	6/22/2010	Start Qty:	6.00			
Required Date:	7/20/2010	Req'd Qty:	6.00			
Reference:						

Approvals:	Process Plan:	Date:	10-6-22	Tooling:		Date:	
	QC:	Date:		SPC (Y/N):		Date:	

Run	Start	
	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3929	A								

100		0.00							
Waterjet		0.00							
FLOW CNC Waterjet									
304 .125									
	Memo								
	1-Cut as per Dwg D3929								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
QC		0.00							
Quality Control									

10-6-23

(C)

10-6-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59979

Tuesday, June 22, 2010 10:16:04 AM



Page 2

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Gusset Assembly

Start Date: 6/22/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 7/20/2010 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

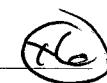
QC8- Inspect parts - second check

0.00

Memo

0.00

S 0106123



140



Large Fab

Large Fab

Memo

Weld bushings D3907-1 as per dwg D3929

0.00

0.00

316L rod batch: 111679

Photo 07-01

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Photo 06

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Page 3

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Accept

Revision ID:

Item Name: Gusset Assembly

Start Date: 6/22/2010 Start Qty: 6.00

Required Date: 7/20/2010 Req'd Qty: 6.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

0.00

170

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

Packaging

0.00

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

10-07-06
(6)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 22, 2010 10:16:08 AM

Page 1

Work Order ID: 59979

Parent Item: D3929-042

Parent Item Name: Gusset Assembly



Start Date: 6/22/2010

Start Qty: 6.00

Required Date: 7/20/2010

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S11GA



304/316 0.125 Sheet

Purchased

No

100

sf

139.2059

0.45

2.842105



1810-6-23

Location

Loc Qty

Loc Code

MAT

139.2059

114488

11.2059

114799

128

114488

D3907-1



Bushing

Manufactured

No

130

Each

44.0000

2

12



(6)
10.07.05

Location

Loc Qty

Loc Code

WA

44

57937

4

59186

40

12

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59929

PS 10-6-22

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D3929-041 GUSSET ASSEMBLY

D3929-042 GUSSET ASSEMBLY

RELEASED
5/6/22

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.04.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3929	REV. A SHEET 1 OF 3
TITLE GUSSET ASSEMBLY	SCALE NTS
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NOTE: Date & initial all entries

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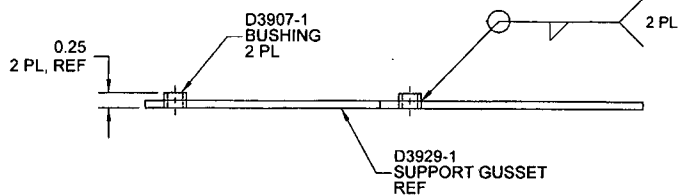
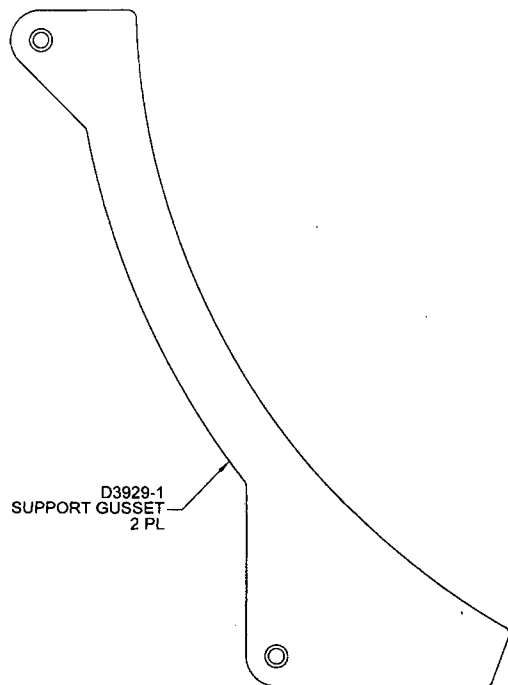
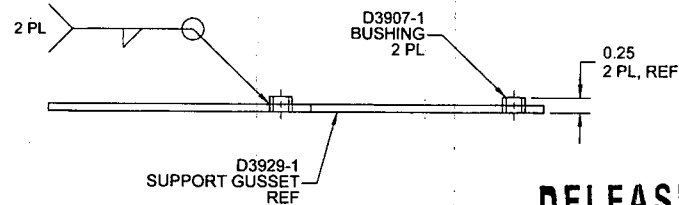
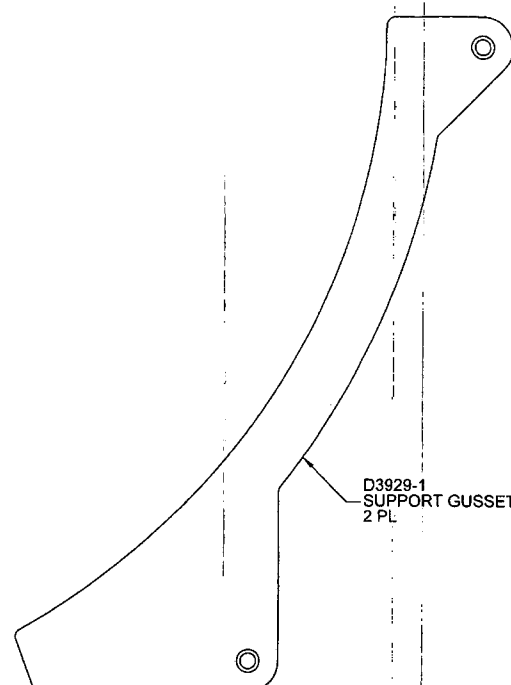
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**D3929-041 GUSSET ASSEMBLY****D3929-042 GUSSET ASSEMBLY****RELEASED**
09/04/22 MD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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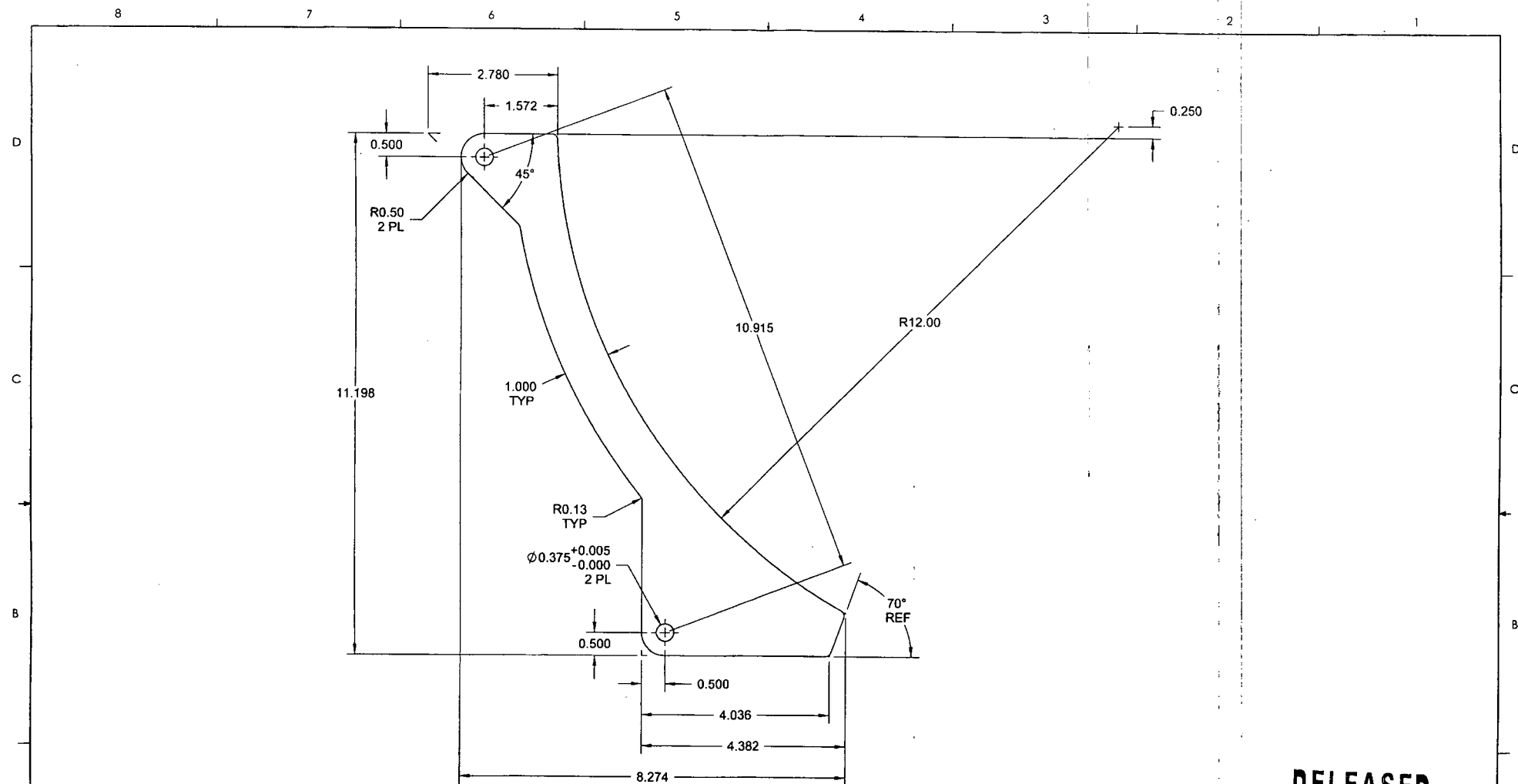
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

RELEASED
9/24/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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